



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-041
Job Sheet 185039



006745

Part No: D4634-041

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G SHEETS 1,2 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY: JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Small Fab-4		SmB
110	Small Fab	1 pcs	11/23/18	11/23/18	0.00	1.00	Small Fab		SmB
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3	DEC 07 2018	9-89
140	QC21-SA	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21	DEC 07 2018	

DAS
70
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	1 Ea (1 ea)	90-Start up Operation	5007846
50-009-2	Grommet	1 Ea (1 ea)	90-Start up Operation	5004860
D4634-141	Fwd, Center Ceiling Replacement Panel Assembly	1 Ea (1 ea)	90-Start up Operation	5135426
D4646-1	Plenum Cap Assembly	2 Ea (2 ea)	90-Start up Operation	5127324
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	90-Start up Operation	5083078
D4728-047	Advisory Light, Fwd	1 Ea (1 ea)	90-Start up Operation	5018504
D4728-051	Cabin Lights #1	1 Ea (1 ea)	90-Start up Operation	5018473
D4743-1	Speaker Grill	2 Ea (2 ea)	90-Start up Operation	5127744
MS21044-N08	Nut	8 Ea (8 ea)	90-Start up Operation	5027549
MS24693-BB50	Screw	8 Ea (8 ea)	90-Start up Operation	5005144
NAS1149DN832J	Washer	8 Ea (8 ea)	90-Start up Operation	5034411
PLT1.5M-M	Tie Wrap	7 Ea (7 ea)	90-Start up Operation	5129712
				5131246

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2351-20-27-C3C	1	37	0
	50-009-2	1	185	0
	D4634-141	1	0	0
	D4646-1	2	16	0
	D4652-5	2	11	0
	D4728-047	1	9	0
	D4728-051	1	4	0
	D4743-1	2	15	0
	MS21044-N08	8	228	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

MS24693-BB50
NAS1149DN832J
PLT1.5M-M

8
8
7

57
1,065
2,169

0
0
0

Part Specifications

Specifications could not be found.

Plex 10/22/18 10:45 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S134240



Part: D4634 - 041

Job No: 185039

Serial No/Batch: S134240

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
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